









Work Order ID 55068

January 5, 2010 2:40:09 PM




Page 1

Item ID: D3594-044 Accept  Setup Start 
Revision ID:
Item Name: Floor Doubler Assembly, RH Stop 
Start Date: 05/01/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 15/01/2010 Req'd Qty: 6.00  Customer:
Reference:
Approvals: Process Plan:  Date: 10-1-05 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3594	Rev B


100  FLOW WATER JET 0.00
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3594 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-1-7

21

110  QC2- Inspect parts off machine FAI/FAIB 0.00
QC Memo 0.00
Quality Control

B 10-1-7

120  QC8- Inspect parts - second check 0.00
QC Memo 0.00
Quality Control

⇒ 5/10/10/8

counter
+20

PTO →

W/O: 55068		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/8	120	Took Qty +1 For QC inspection template	S	10/1/6	+1		S 10/1/08

Part No: D3594-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55068

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Page 2

Item ID: D3594-044

Accept



Setup Start



Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 05/01/2010 Start Qty: 6.00

Required Date: 15/01/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

C'SINK AS PER DWG D3594

Signature: [Handwritten Signature]
Date: 10/01/11
Stamp: (20)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8/10/11

Stamp: (420 -044)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Signature: [Handwritten Signature]
Date: 10-01-12

Stamp: (20)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55068

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Floor Doubler Assembly, RH

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

M

10-01-12

(X20)

0

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates As per Dwg D3594

E/S 10/01/13 (20)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> 8106013

counties
(A20)

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

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Setup Start



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Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10/01/13 (20)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14

mk 10-1-13

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:40:14 PM

Page 1

Work Order ID: 55068

Parent Item: D3594-044

Parent Item Name: Floor Doubler Assembly, RH

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4 Rivet		Purchased	No			100	Each	2,667.000	12.0000		05/01/13	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2667	
15541	2667	

M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			170	sf	275.3809	3.2211			
------------------------------------	--	-----------	----	--	--	-----	----	----------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	275.38087	
110630	33.5136	
112141	0.86727	
113438	241	

MS21069-5 Anchor nuts		Purchased	No			170	Each	12.0000	6.0000			
--------------------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	12	
111310	12	

M113627 (20x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

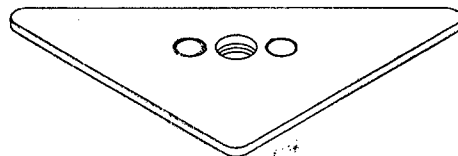
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

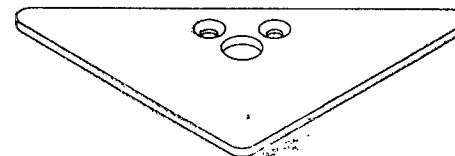
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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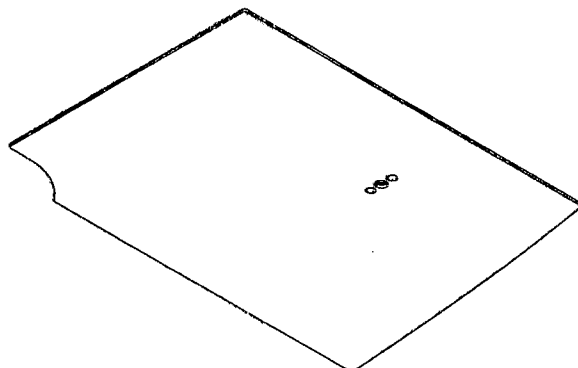
NOTE: Date & initial all entries



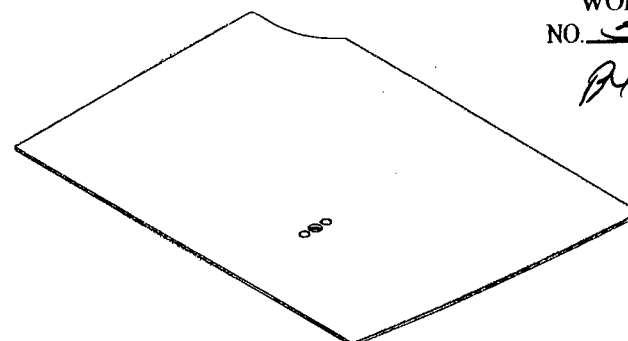
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMEN
WITHOUT NOTICE
WORK ORDER
NO. 55068

2/10-1-05

RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD 5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SOME
DE APPR.		DOUBLER	NBS
DATE	08.05.14	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT NOT BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

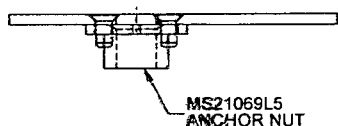
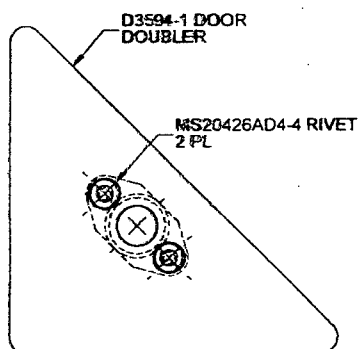
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

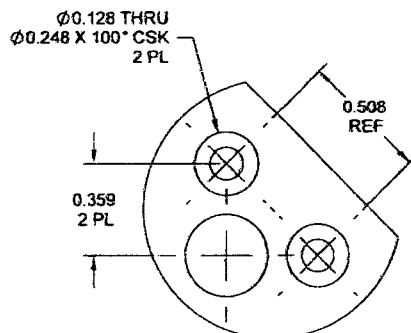
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

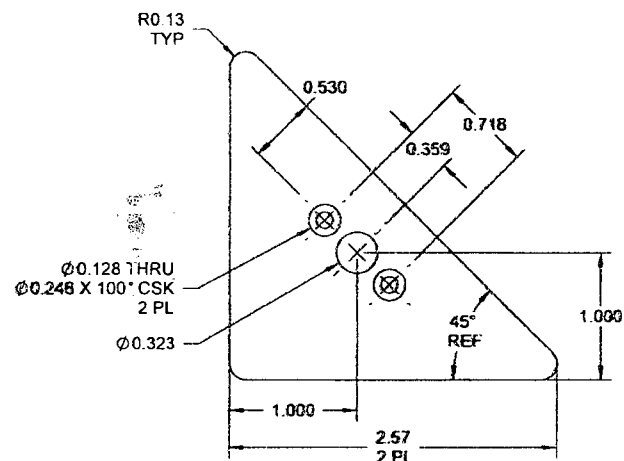
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



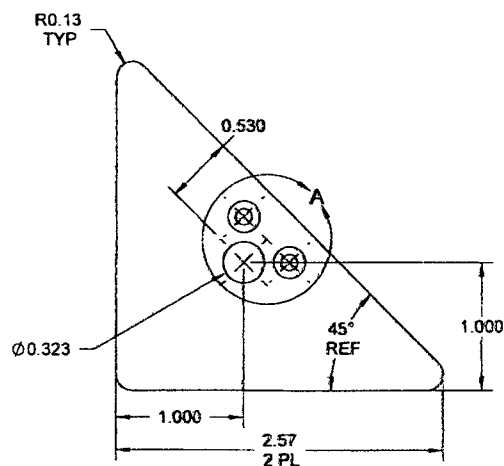
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

RELEASED
28-05-76

NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M5061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 8) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE DOUBLER	SCALE NTS
DE APPR.			
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

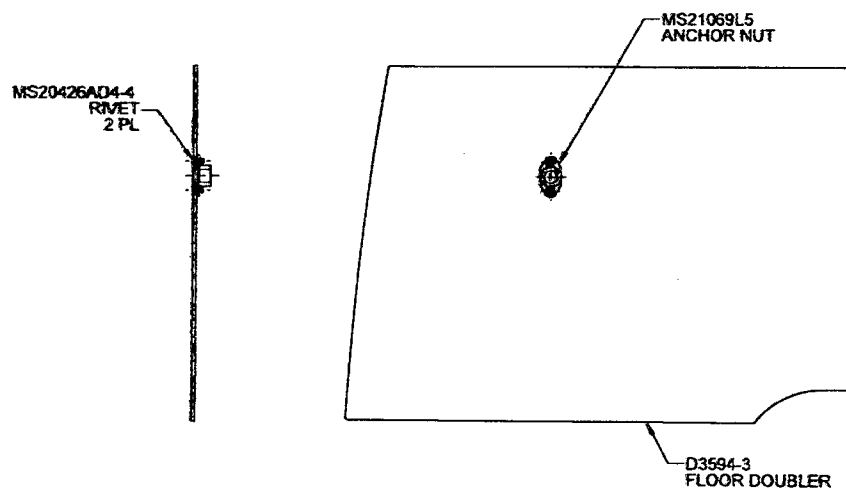
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

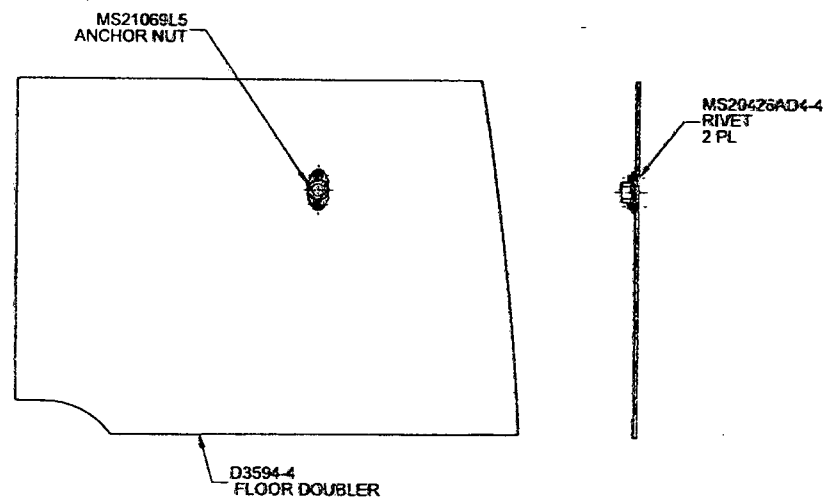
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

1) MATERIAL: -3 & -4

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. MS061T6S.080)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) WEIGHT -043 & -044: 0.80 lbs

RELEASED
108-06-22-14

W/O 55068

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	DS	D3594	SHEET 3 OF 4
APPROVED	AA	TITLE	SCALE
DE APPR.	SA	DOUBLER	NTS
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

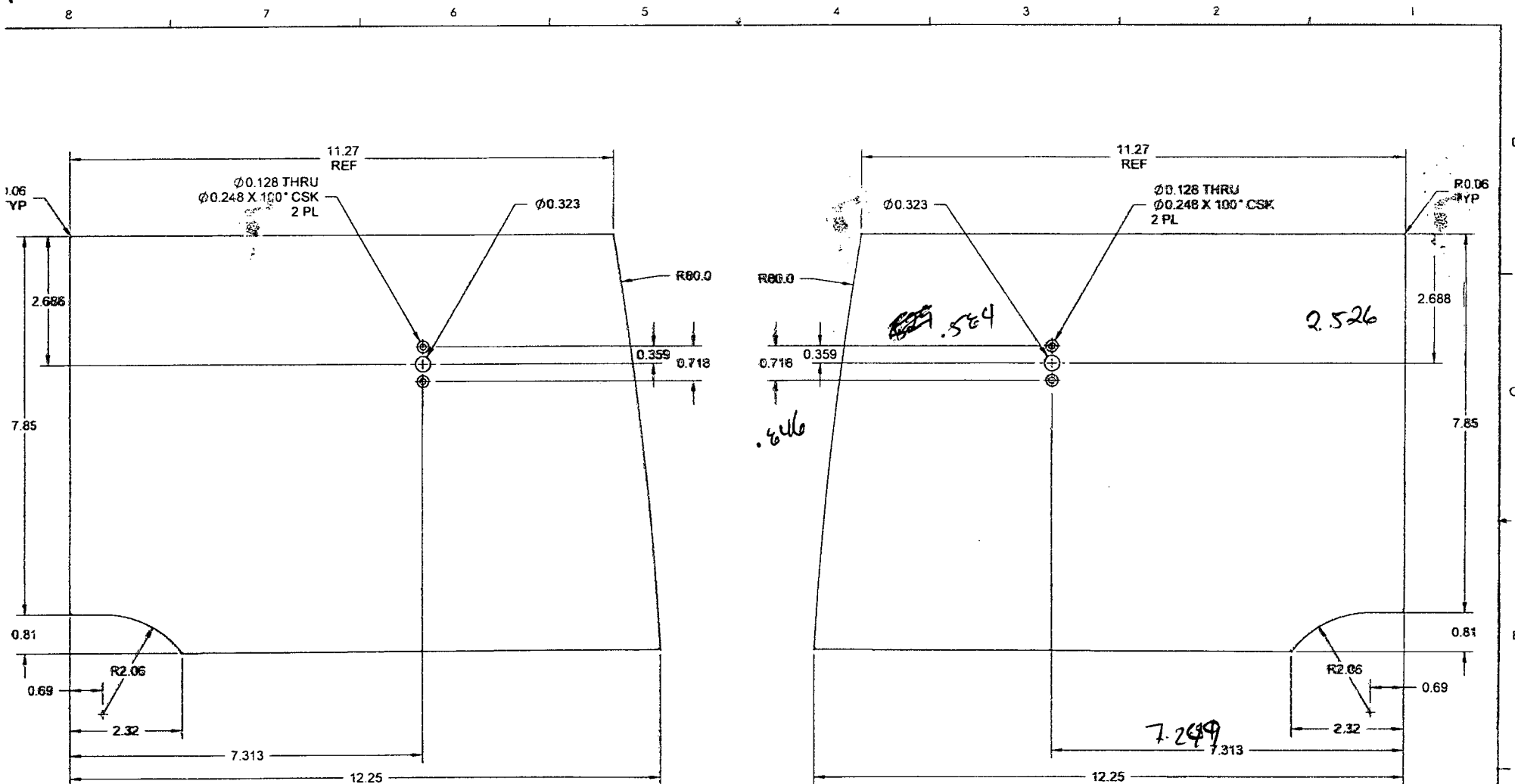
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NOTE: Date & initial all entries



D3594-3 FLOOR DOUBLER

D3594-4 FLOOR DOUBLER

RELEASED
0804-36-17

DESIGN	AJS	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR DOUBLER ASSEMBLY	NTS
DATE	08.05.14	<small> COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

109
064.161

W/O:		WORK ORDER CHANGES					
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